

Work Order ID 51959

September 10, 2009 2:57:15 PM

Page 1

Item ID: D350-636-105A

Accept

Setup Start

Revision ID: A

Stop

Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00

Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-9-10 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9456

A

100

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-636-105A/ DSI9456
CHG001

8/9/10/20

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

9/9/30

(40) SP

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

2) 8/9/10/20

(24) /

Work Order ID 51959

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Page 2

Item ID: D350-636-105A

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D3550-636-105A/ DSI9456								
	Location:								
	PPP rev:								
140	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/10/26

(4) SP

9/10/28

W.O. 10.27

Picklist Print

September 10, 2009 2:57:14 PM

Work Order ID: 51959

Parent Item: D350-636-105ARevA

Parent Item Name: Wedge Installation

Comments:

Start Date: 9/14/09

Required Date: 9/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3926-1RevA

+2

Manufactured

No

110

Each

2.0000

8.0000

(2)

51962 SP

Wedge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

51411

2

110

Each

3,754.000

16.0000

BS2919 9/10/21 (6x) SP

MS21042L3

+4

Purchased

No

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3754

110844

32

111274

230

111668

992

112314

2000

112385

500

110

Each

146.0000

16.0000

(10x) 111274 (6) 111668 SP

MS24693-S276

+4

Purchased

No

SCREW

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

146

104374

146

104374 SP

9/9/30 (40) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

September 10, 2009 2:57:15 PM

Work Order ID: 51959

Parent Item: D350-636-105ARevA

Parent Item Name: Wedge Installation

Comments:

Start Date: 9/14/09

Required Date: 9/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

5
+4

NAS1149D0363J

(4)

Purchased

No

110

Each

2.0000

16.0000



Washer

9/9/30 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

112314

2

tb /

September 10, 2009 2:57:15 PM

Shop Packet Print

Page 2

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skid tubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skid tubes but is not compatible with OEM skid tubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31909

A	NEW ISSUE	09.07.23
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DESIGN	AS	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	AS	
CHECKED	ASS	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9456 SHEET 1 OF 3
APPROVED	10/11	TITLE SCALE
DE APPR.	10/11	WEDGE KIT NTS
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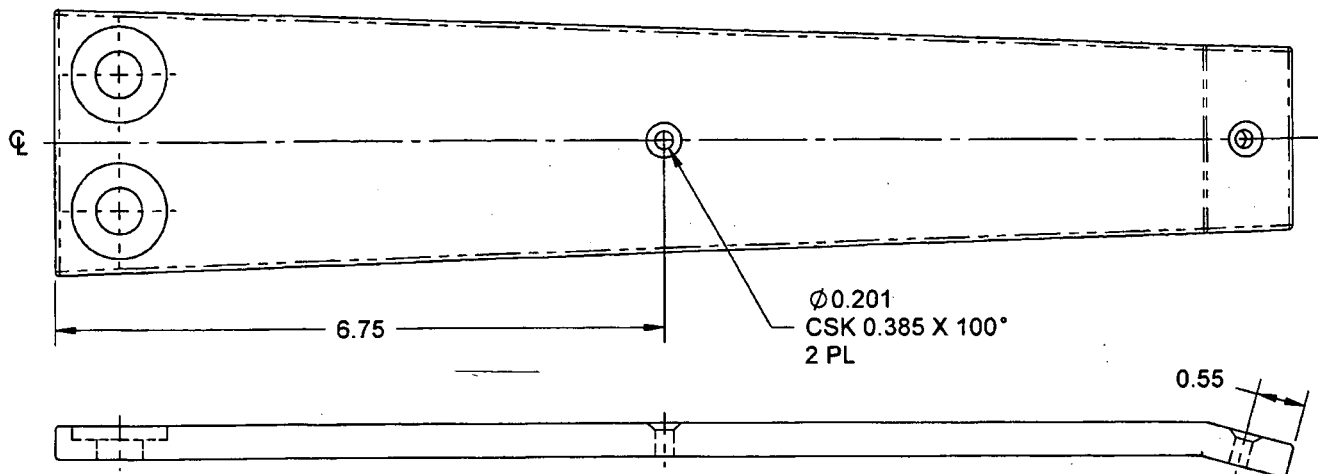


FIGURE 1: D2741 BLADE DRILLING DETAIL

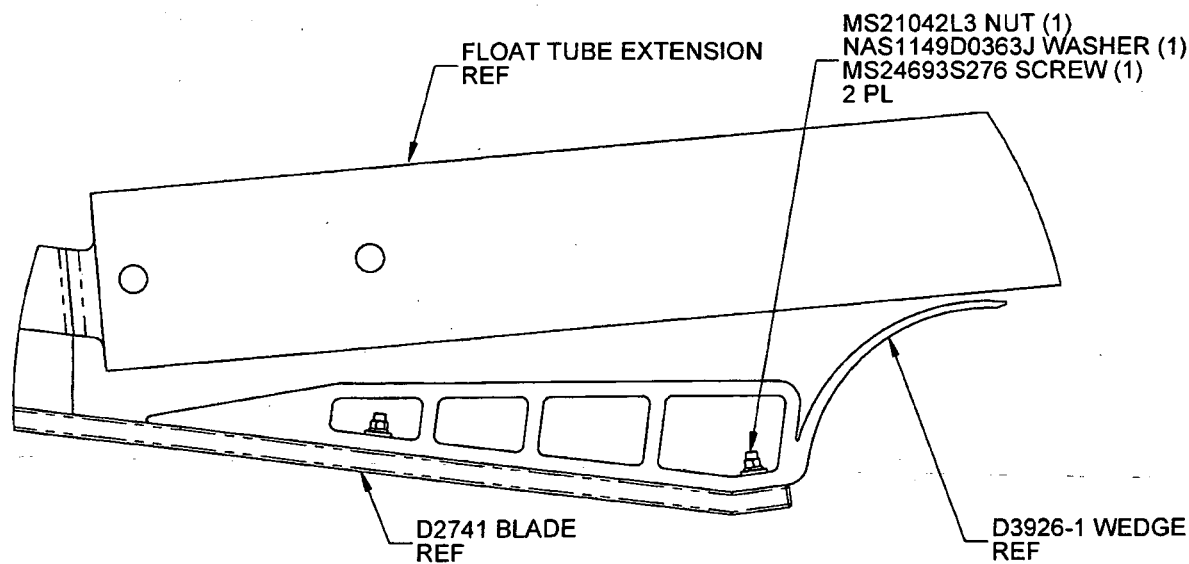
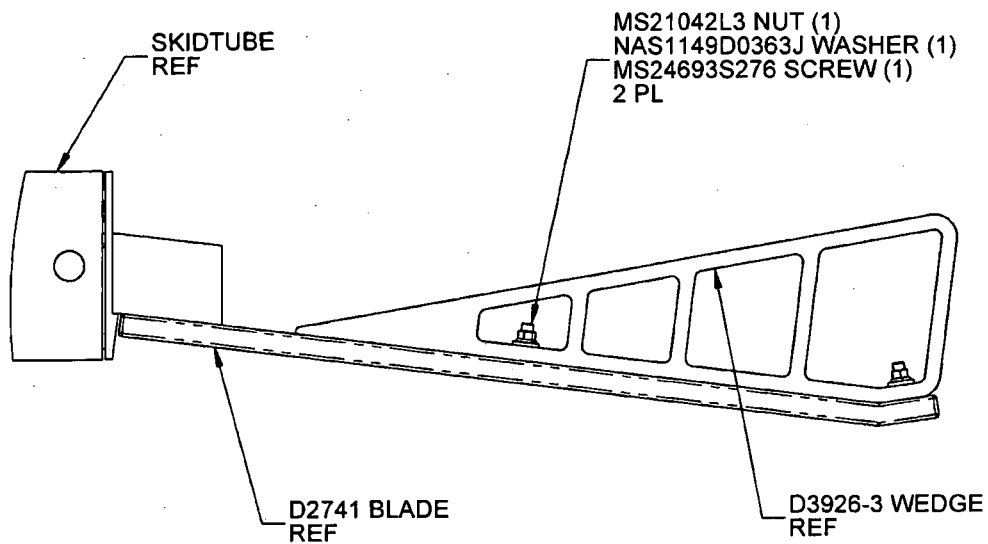


FIGURE 2: D3926-1 WEDGE INSTALLATION

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CHECKED	<i>AJS</i>	DRAWING NO.	REV. A
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W/O 519.55

FIGURE 3: D3926-3 WEDGE INSTALLATION

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MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	WEDGE KIT	NTS
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REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

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D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

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	X	D350-636-105B	Wedge Kit
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	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J /	WASHER

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Work Order ID 51959

September 10, 2009 2:57:15 PM



Item ID: D350-636-105A

Revision ID: A

Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00

Required Date: 9/24/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *PL*

QC:

Date: *09-9-10* Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9456

A

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-636-105A/ DSI9456
CHG001

0.00

PL 091024

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

9/19/30 (40) SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

REFERENCE ONLY